

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 39886-1
 Estimate Number : 10010
 P.O. Number :
 This Issue : 16/06/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 39241
 Written By :
 Checked & Approved By : JUL 08. 0.14
 Comment : Est Rev:C Removed from 9 Digit 05-10-25 JLM
 Est. C 06.07.21 waterjet EC

Drawing Name : LUG BRACKET
 Part Number : D27353
 Drawing Number : D2735 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 30/06/2008 Qty: 60 Um: Each

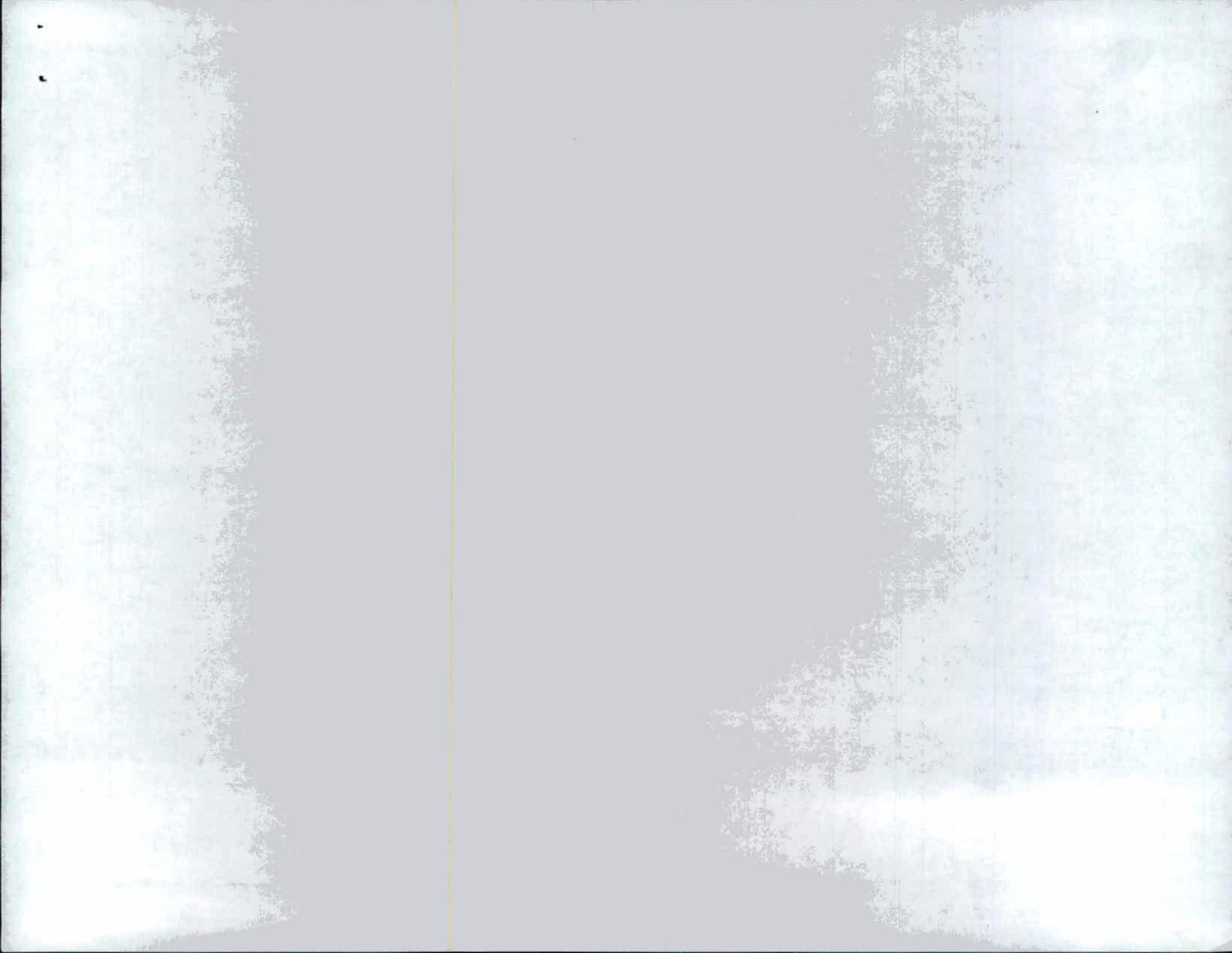
Additional Product

~~UNDER REVIEW~~*W 08.12.08*

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet.125
	Comment: Qty.: 0.1733 sf(s)/Unit Total : 1.0395 sf(s) 1010-1025 sheet .125 batch: <u>10833</u>	<i>AB 8-7-21</i>
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2735 Dwg Rev: <u>C</u> Prog Rev: <u>C</u>	<i>AB 8-7-21</i>
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>AB 8-7-21</i>
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<i>S 08/07/21 +60</i>
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required.	<i>S 08/07/21 04 EF 08/07/21 04 ⑩</i>



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 39886

Part Number: D27353

Job Number:

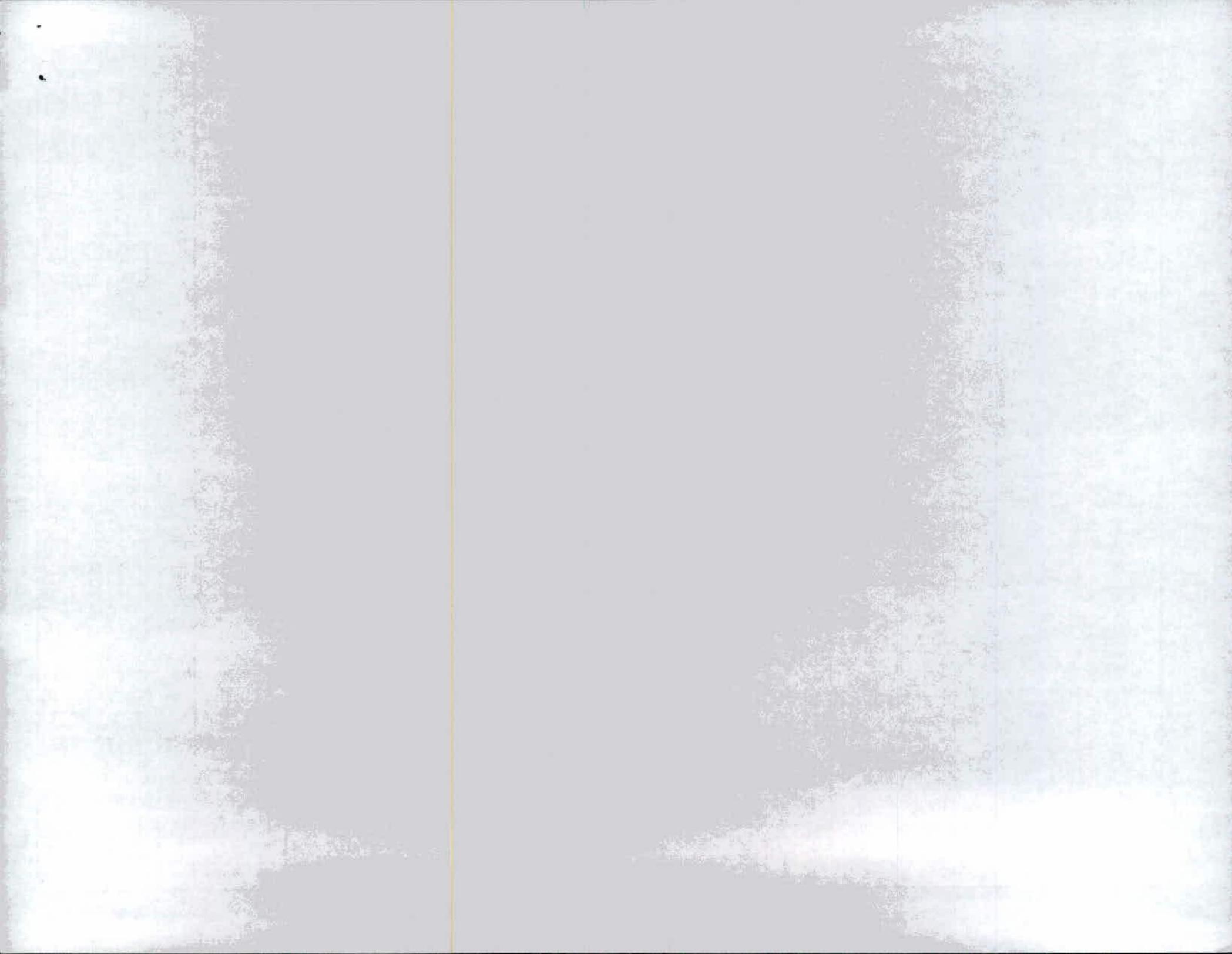


Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		S 08/12/05 (x11)
Comment:	INSPECT WORK TO CURRENT STEP	
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		Eric L ✓ 88 08/12/05 (x11)
Comment:	PACKAGING RESOURCE #1	
	Identify and Stock	
	Location:	
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		08/12/05 (x11)
Comment:	FINAL INSPECTION/W/O RELEASE	

Job Completion



u 08.12.05



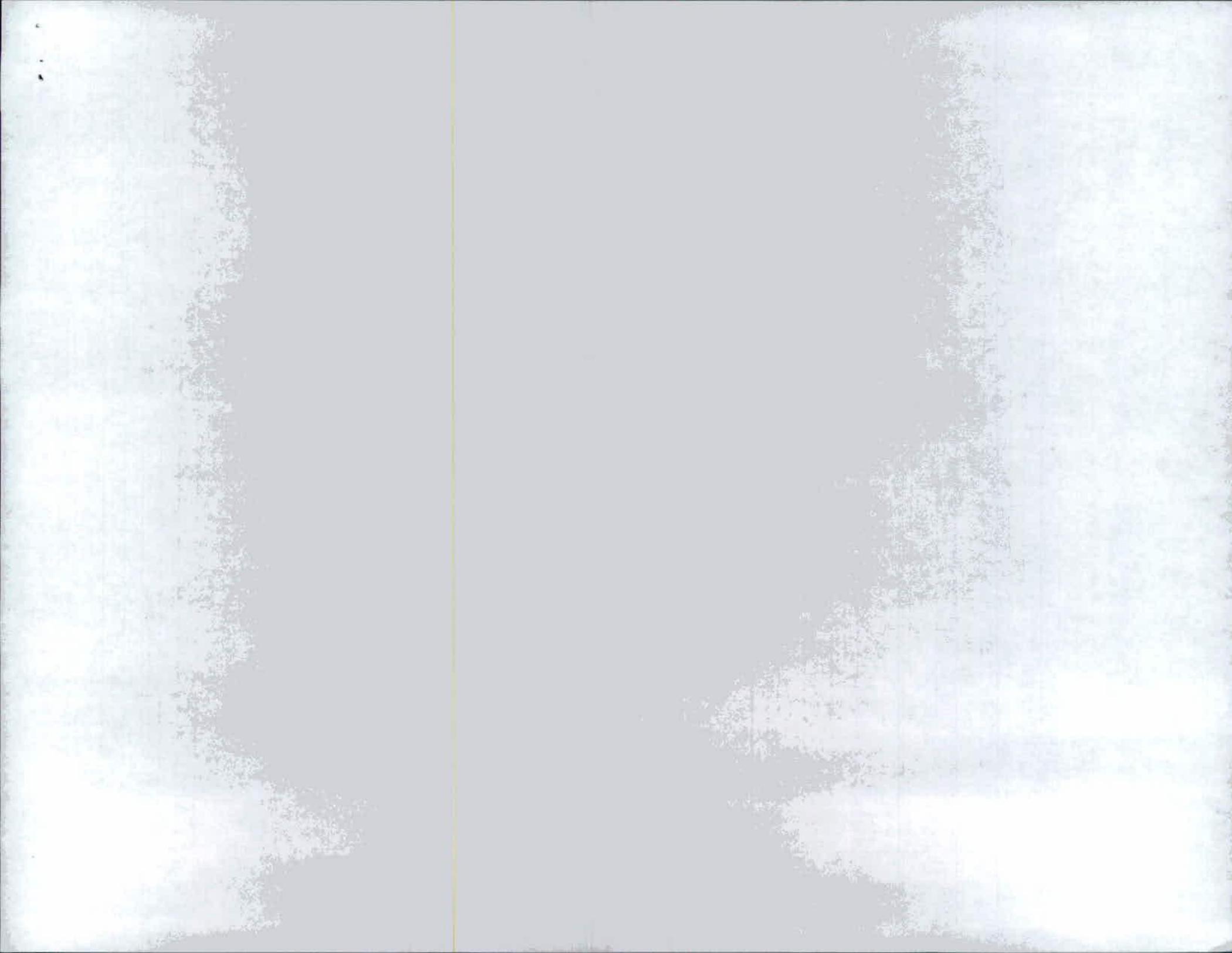
DART AEROSPACE LTD	Work Order:	39886
Description: Lug Bracket	Part Number:	D2735-3
Inspection Dwg: D2735 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

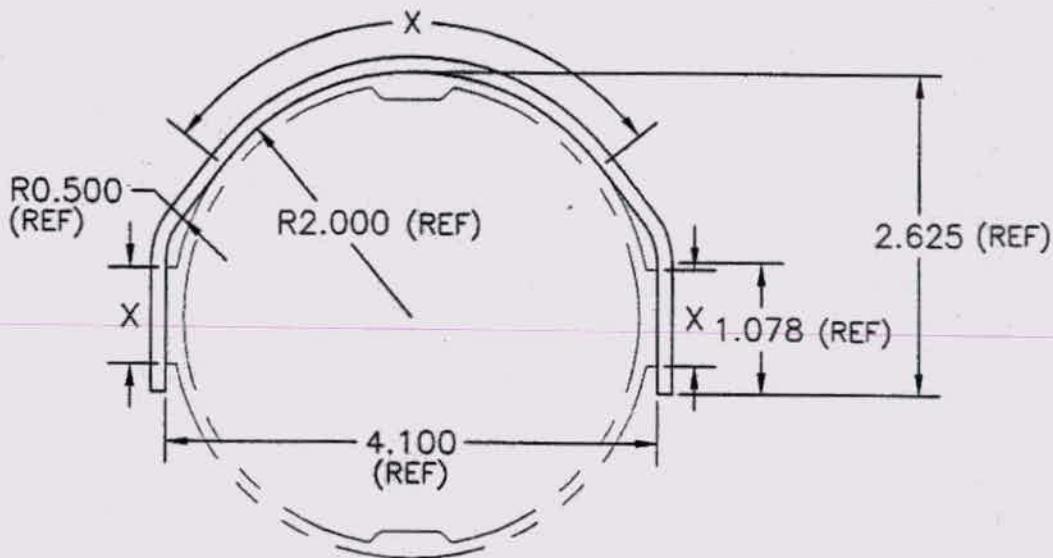
Measured by:	IB	Audited by:	J	Prototype Approval:	N/A
Date:	8-7-21	Date:	08/03/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	JL



DART

DESIGN <i>SH</i>	DRAWN BY <i>SH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735
DATE 98.12.14		REV. C SHEET 2 OF 2 TITLE LUG BRACKET SCALE 2:3

RELEASED
98.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39886

